	e r ID 76494 ber 15, 2011 3:59:21 Pl	М		*764	194*							Page 1
Revision ID:	D3324-041 Basket Base Assembly			Accept	*N900	040	100	* S		art top	*N.	31* 32*
	11/15/2011 Start Qty		*1* *1*		Cust Item I Customer:	D:						
Reference:				· · · · · · · · · · · · · · · · · · ·			_	R	tun St	art	481 5	744
Approvals:	Process Plan:		ate://-//5 ate:	Tooling: _ SPC (Y/N):		ate: ate:				ton	^NF *NF	₹1* ₹2*
Sequence ID/ Work Center II	Operation Description			Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty			Insp. Stamp
Draw Nbr	Revision Nbr		,									
D3324	Rev B											
100 *100* Large Fab	Large Fab	Memo		0.00			4	SY	11/	11/2	5 (].	3
Large Fab		1-Cut tubes as pe Qty Part Num 3 D3324-1 4 D3324-3 2 D3324-5 10 D3324-9	ber Description Bottom Tube Full Length Tul Top End Tube Bottom EndTu	M119404 be N119404								
		2- Weld as per dv A/R 4130 rod b	vg oatch: <u>4/18</u> 875						· •			
110	QC9- Inspec	et visual per QSI00	04- Fusion Welds	0.00				_			200	
110 QC		Memo		0.00			_		Ð		15-L-11-	11-28

Quality Control

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PROC	CEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Dort No.	_	DAD #-	F		NOD. V.	N		D-4	1				
Part No		PAR #:											
	R	esolution:						Date: _					
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o	& Secti	ion C	Chief Eng	QC Inspector				
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Work Orde Tuesday, Novem				*764	194*							Page 2
Item ID: Revision ID:	D3324-041			Accept	*N900	040	100)* s	Setup	Start Stop	1 41	S1*
Item Name: Start Date: Required Date:	Basket Base A 11/15/2011 11/25/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					"IXI	S2*
Reference: Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:	_	I	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II		Operation Description QC5- Inspect part comp		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
120 QC Quality Control		Memo		0.00				1.:		<u>u</u>	· ·	<u> 28 (</u> (
121 *1 21		Pressure Wash per QSI0	05 4.3	0.00			/	XØ	M	1-J.	/	11/28
HandFinish		Memo		0.00			,		•		011	MU

Hand Finishing

W/O:		WORK ORDER CHANGES											
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	Res	solution:	Disposition	ı:	_ QA: N/C (Closed:		Date: _					
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)							
DATE	STEP	Description of NC			ion B		cation	Approval	Approval				
	-	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector				

	Work Order ID 76494 Fuesday, November 15, 2011 3:59:21 PM			*76494*								Page
Item ID:	D3324-041			Accept	*N900	040	100)*	Setup	Start	*N	S1*
Revision ID:										Stop	481	00*
Item Name:	Basket Base A	Assembly								осор	^ N	S2*
Start Date:	11/15/2011	Start Qty: 1.00	*1*		Cust Item II	D:						
Required Date:	: 11/25/2011	Req'd Qty: 1.00	*1*		Customer:							
Reference:							_		ъ.	Staut		
Approvals:	Process Pla	an:	Date:	Tooling: _	Da	te:			Run	Start	*N	R1*
	QC:		Date:	_ SPC (Y/N):	Da	te:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
130		White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00			>	(1.0	/ 1	.1	/,,,	100
130 Powdercoat		Мето	~ 210	0.00			//	XØ	1/1	1/4	////	1/28
Powder Coating	4391	IST COAT START TIN OVEN TEN FINISH TIN	ME: 40	0(- D					,			
W(100	J	OVEN TEN	1/6/2	Jol-								·
1.40		OC2 Inchect Part Finis	, -1	0.00					Λ	Λ		n

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Quality Control

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QC3- Inspect Part Finish

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		Section A	Chief Eng	Chief Eng	Date	Section	on C	Chief Eng	QC Inspector
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Work Ord Tuesday, Novem				*764	194*				Page 4
Item ID: Revision ID:	D3324-041	The state of the s		Accept	*N900040	100*	Setup	Start Stop	*NS1*
Item Name: Start Date: Required Date	Basket Base A 11/15/2011 : 11/25/2011	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			·	*NS2*
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 150 *150* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location: 6 A W/0 76490 (10)	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Acce Code Qty	pt Re Qt		Reject Insp. Number Stamp
160 *160* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00				n)11	129 H

11-11-29

W/O:		WORK ORDER CHANGES											
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector				
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Picklist Print

Tuesday, November 15, 2011 3:59:25 PM

Work Order ID: 76494

76494

D3324-041

Parent Item:

D3324-041

Parent Item Name:

Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A05.02.09New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3		Manufactured	No			100	Each	18.0000	2	² //) ;		
D3328-3 Basket Hinge									**	DY.	// ///E	13	
				Location	l	Loc	Oty	Loc Code					
				WA005			18			(3)	_		
					33872		18	15,0000	4		-		
D3348-1		Manufactured	No	•		100	Each	15.0000	4	⁴].	/ /	/	
D3348-1									**		1 ///	11/2	3
•				Location	<u> </u>	<u>Loc</u>	Oty	Loc Code					
				WA			14				_		
					75575		14		_	(41)	-		
				WA005			1		_				
			NI.		44246	100	I Each	4.0000	2	2	_		
D3349-3		Manufactured	No			100	Lacii	4.0000	_		. C		11/11
D3349-3	'								^^ -	B756	20 6	<i>لوک</i> (روا	W 11/1
Spacer Dushing				Location	!	Loc	<u>Oty</u>	Loc Code					
				WA			4		_				
					72930		4		_		_		
D3367-1		Manufactured	No			100	Each	8.0000	2	2			11 .
D3367-1 Mounting Bracket									** -	B76	500 (8	2x)	1311
C				Location	_	<u>Loc</u>	Oty	Loc Code					
				WA005			8		_		_		
					43228		8		_		_		

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DATE	STEP	Description of NC		Corrective Action Section		Verification	on Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Picklist Print Tuesday, November 15, 2011 3:59:26 PM				Page 2
Work Order ID: 76494	*76494*			
Parent Item: D3324-041 Parent Item Name: Basket Base Assembly	*D3324-041*		Start Date: 11/15/2011 Start Qty: 1.00	Required Date: 11/25/2011 Required Qty: 1.00
M4130NTS0.500W.035 Purchased	No	100 f	307.3682 46.6 49.0526	53
M4130NTS0 500W 035			** B1196	33 -> 49.0526
1150 Square troot 1500 A 1500	Location	Loc Qty	Loc Code	1.1
	MAT034	307.3682		= 11/11/25
	109127	158.152 15.75		- 500 11/11/23
	109385 112786	39.2488		-
	119441	57.8774		_
	119506	36.34		_
*M569EX0.50-18F Purchased *M569FX0 50-18F* 569 Expanded Metal	No	100 sf	146.0000 28 28	11/11/21
365 Expanded Mem	Location	Loc Qty	Loc Code	
	MAT018	146		
	112776	10		
	117806	4		_
	119226	4	(an)	<u> </u>
	119404	128	(' 	_

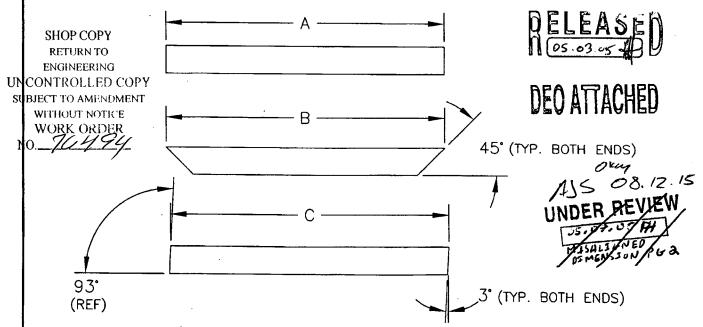
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į	CHECH	(ED)	APPROVED /	DRAWING NO.	REV. B
	•	4	#\-	D3324 SHEET	T 1 OF 3
	DATE			TITLE	SCALE
	05.0	3.04		BASKET BASE ASSEMBLY	NTS
	Α		04.10.20	NEW ISSUE	
	В		05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



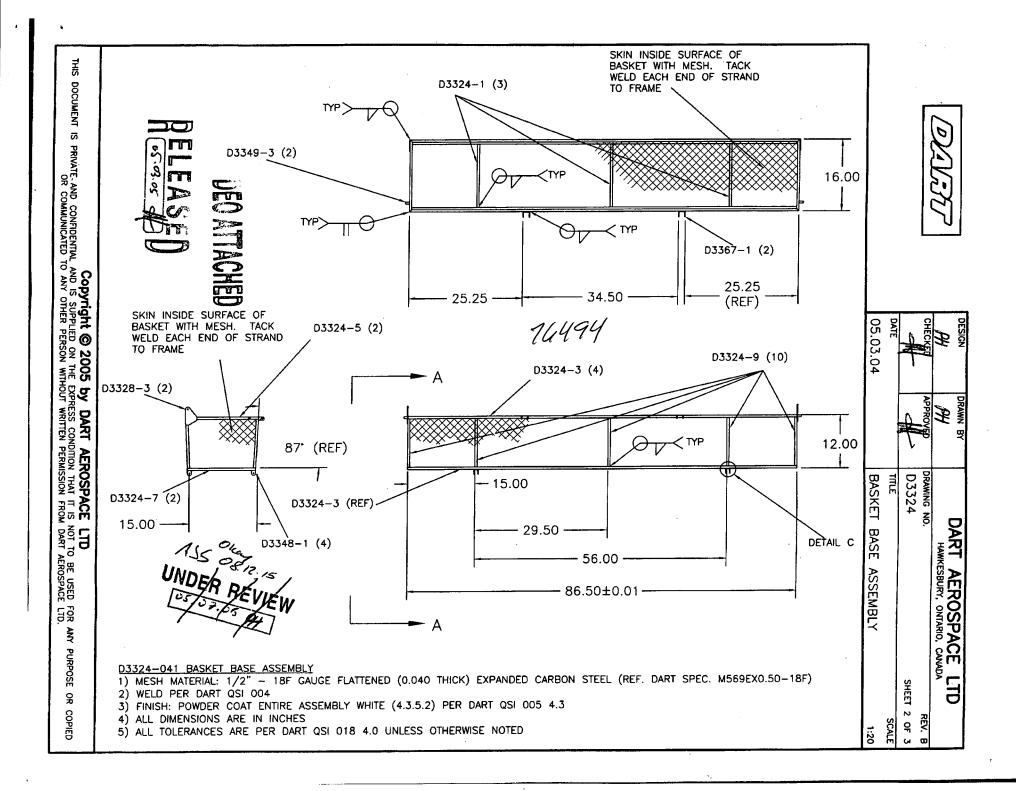
D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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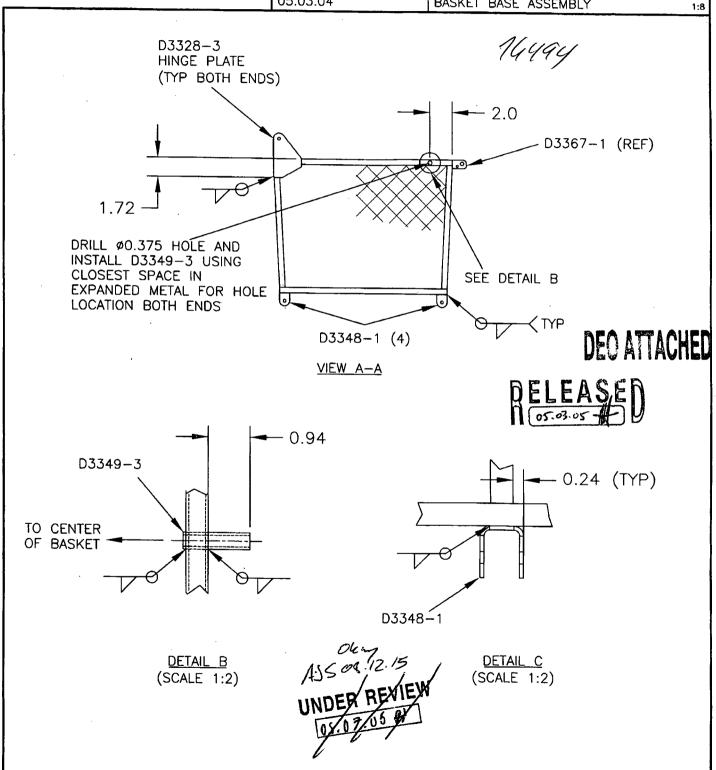
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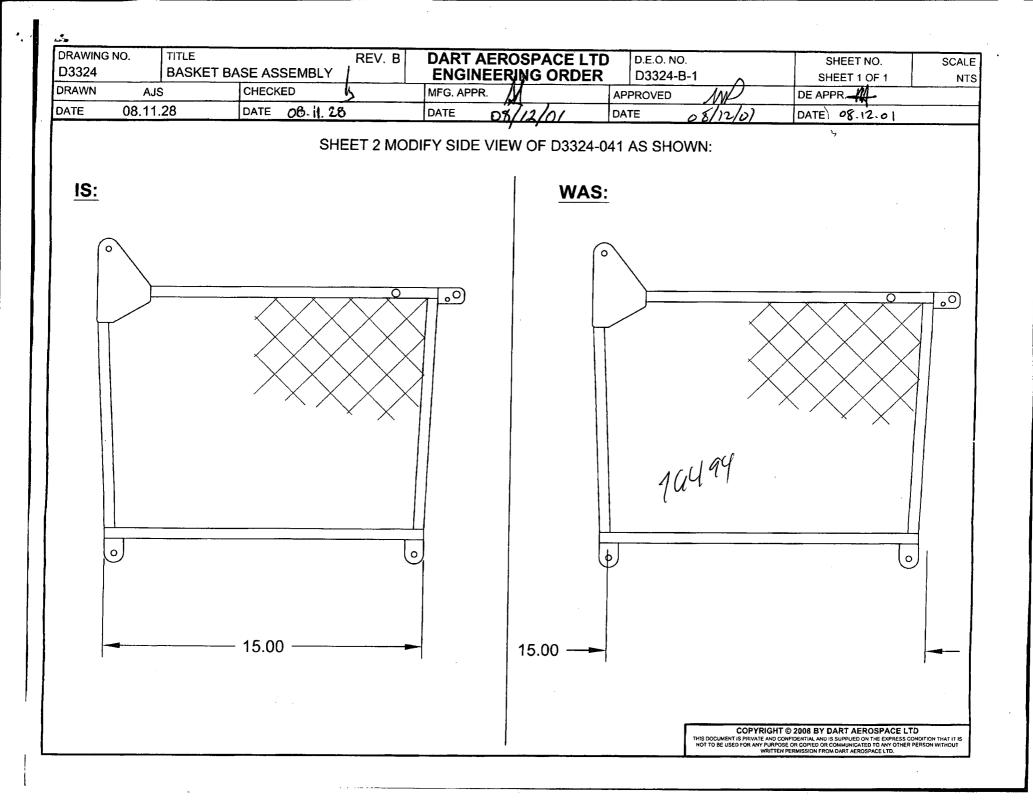
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CHECKED	APPROVED	DRAWING NO. D3324	REV. B SHEET 3 OF 3
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05.03.04		BASKET BASE ASSEMBLY	1:8



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DATE	STEP	Description of NC Section A		Action Description	Sign	& Section			Approval QC inspector		
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Dart Aerospace Ltd W/O: WORK ORDER CHANGES **Approval** Approval QC Inspector DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR-

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